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1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D135-751-011
Job Sheet 183647



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/26/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD VERF:JLM

Ship Via:



Container No: S113906



Part: D135-751-011

Job No: 183647

Serial No/Batch: S113906

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 15/10/20 TC LoA RDIMS

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Powder Coct.

START: 8:00

TEMP: 320°

FINISH: 8:30

Time worked: 10 mins

M138951

BEB 2018-10-22

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/26/18	10/26/18	0.00	0.00	Start Up Skidtubes-1		
120	Skidtubes	1 pcs	10/26/18	10/26/18	0.00	0.80	Skidtubes-1		DAS
140	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.33	HandFinish1		D.R. 18/10/13
160	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC7-1		1749
170	Skidtubes	1 pcs	10/26/18	10/26/18	0.00	1.00	Skidtubes-1		D.D. 138
180	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC10		9-88
185	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.10	HandFinish6		BEB 18-10-13
187	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC7-1		D.R.
190	Skidtubes	1 pcs	10/26/18	10/26/18	0.00	0.77	Skidtubes-1		DAS
200	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		38
210	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.08	HandFinish2		D.R. 18/10/16
215	Outsource	1 pcs	10/26/18	10/26/18			ATE003-VC	5	1749
220	SprayPaint	1 pcs	10/26/18	10/26/18	0.00	0.25	Spray Paint	powder coat	1749
230	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC14		AL 18-10-29
260	HandFinish	1 pcs	10/26/18	10/26/18	0.00	0.74	HandFinish4		AL 18-10-29
270	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC5		OCT 23 2018 68
280	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging1-1		OCT 24 2018 89
290	QC	1 pcs	10/26/18	10/26/18	0.00	0.00	QC4		DAS
300	Packaging	1 pcs	10/26/18	10/26/18	0.00	0.00	Packaging3-1		21
305	DC	1 pcs	10/26/18	10/26/18	0.00	0.00	DC		9-88
310	QC21-FG	1 Ea	10/26/18	10/26/18	0.00	0.00	QC21		DAS

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375"(1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: _____

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Job BOM					Container
Part / Item	Component Name	Quantity	Operation		
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation		00686
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes		5089120
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes		5077412
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes		105604
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes		5092232
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes		5084958
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes		5091974
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes		5091971
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish		5066193-1
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish		5058138
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish		5084128
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish		5095223
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish		5095214
D2965	Cap	1 Ea (1 ea)	260-HandFinish		5071644-2
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish		5045482
D3492-1	Plug 5090814(x2)	4 Ea (4 ea)	260-HandFinish		F126369
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish		5107238
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish		502/ 5107030
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish		F106110
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish		5096801
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish		5089866
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish		5081647
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish		5081645
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish		5089465
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish		F103697
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish		5106792
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging		5057659
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging		5090636
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging		5109370
					5104354

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	2	0
170-Skidtubes	D3504-1	2	12	0
	D3504-3	1	18	0
	D3504-5	2	38	0
	D3505-1	1	6	0
190-Skidtubes	D3506-1	4	48	0
	D3506-3	2	28	0
	MS20601-AD4W3	12	889	0
260-HandFinish	ALS4-1032-225	1	1,947	0
	ALS7-1032-130	38	1,267	0
	AN3C4A	31	2,249	0
	AN3C5A	2	1,934	0
	AN526C1032R10	2	110	0
	D2965	1	50	0
	D2965-3	1	10	0
	D3492-1	4	108	0
	D3492-3	4	153	0
	D3492-7	2	19	0
	D4918-047	1	7	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	3	0
	NAS1149C0332R	33	5,199	0
	NAS1611-007	2	270	0
	NAS1611-010	4	433	0
	NAS1611-013	4	290	0
280-Packaging	AN3C4A	8	2,249	0
	D3512-041	2	5	0
	NAS1149C0332R	8	5,199	0

Part Specifications

Specifications could not be found.

Plex 9/21/18 3:59 PM dart.white.jesse

REFERENCE ONLY

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

REFERENCE ONLY

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Revision: C

Date: 07.09.20

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER

REFERENCE ONLY**32.9 PARTS LIST (ICA-D135-751)****5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

REFERENCE ONLY

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	OP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9661	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	REVISED WEARPLATE KIT	NTS
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